

Abstract:

A description is given of a mold for manufacturing concrete moldings, e.g. paving setts, large-volume blocks and large-format, thin panels, having a bottom mold part which comprises the mold chamber(s) and having a top mold part with a load plate and the die or the dies. The bottom die parts (47) which come into contact with the concrete in each case are guided so as to be movable in the vertical direction, with respect to the top mold part, in a displacement range defined by stops (46, 51, 53) and are exposed to the action of a pressure medium, e.g. a bellows (40) activated by compressed air. The manufacturing process claimed works with two successive fillings. After the first filling pre-compaction is carried out at a relatively high pressure, and after the second filling secondary compaction is carried out at reduced pressure, the reduced pressure resulting in desired striking of the movable die part against the other die in the same rhythm as the vibrations.